Work Order <i>July-12-13 10:03:</i>		70		*104	l 47 0*							Page 1
Item ID: D Revision ID: Item Name: St	2237 triker Plate	tart Qty: 20.00	*20*	Accept	*N900 Cust Item I		100)*	Setup	Start Stop	171	S1* S2*
Required Date: 7/		keq'd Qty: 20.00	*20*		Customer:	υ.						
Reference:			2()						_	<i>~.</i>		
Approvals:	Process Plan:	MLJ	Date: 13-07-16	Tooling:	Da	ate:		•	Run	Start	171	R1*
·			Date:	SPC (Y/N):	Da	ate:				Stop	*N	R2*
Sequence ID/ Work Center ID		peration escription		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Re Qt	•	Reject Number	Insp. Stamp
Draw Nbr	Revisio	on Nbr		c			دع		•			
D2237	Rev D1	1	*				`					- Alexander - Alex
*100 *100* Waterjet FLOW CNC Waterjet	FL		r Dwg D Dwg Rev:_ <i>D</i>]	0.00 0.00 Prog Rev: <i>Of</i>	2-Deburr		t	70	<u> </u>	<u>e</u>		<i>Jn13</i> 0730
		if necessary										
; ; 110	Q	C2- Inspect parts off n	nachine FAI/FAIB	0.00								
110 QC Quality Control		Memo	•	0.00			·	<u> 7</u> c	<u> </u>	<u>ت</u>		Jm13-07-30
120	Q	C8- Inspect parts - sec	ond check	0.00							.)A 0
120 QC Quality Control		Мето		0.00				_&S) 13	-07	30	09

DQA:			Date:			MODIL ODDED MON	~	-NEO	DAAANGE / LIDDATE				•	
QA Closed:			Date:			WORK ORDER NON-	-C(JNFO	RMANCE / UPDATE	W	ork Order up	odate only		AEROSPACE
M						DISPOSITION			AGAINST	DE	PARTMENT	/PROCESS		
Work Orde	er:		-			Down or l					1	18/atau 1at		En aire a nin a
Part N	۷n					Rework Scrap			Skid-tube Crosstube Machining Small Fab	-	Pro	Water Jet d. Eng. Coor.	\dashv	Engineering Quality
raici	•0. –					Use-as-is			noforming Finishing		4	e/Packaging	\dashv	Other
NCR I	۷o.					Suspected Unapproved		111.011	Large Fab Composite	_	1 1100,3101	Supplier	┪	
					_				0		J			L
Root					Desci	ription of work order update	1	nitial	Action		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification		QC Inspector
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Material	H					•								
Operator	Н													
Offset/Setup	Н													
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, , <u></u>			<u> </u>	.	·		FAI	ULT CA	TEGORY		1			
Landi	ng G	ear				General						- ****		
		Bending				Bend		Folio/F	Program		Outside Dim	ensions		Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance		Set-up
		Cracks				Broken/Damage/Defect		Hardwa	ire		Part Incorred	ct [<u> </u>	Temperature/Cure
	Щ	Crimp/Kir	nk/Ripple	/Wave	<u> </u>	Burrs		Inspect	ion Incomplete/Unqualified		Part Lost/Mi	ssing [Weld
		Cuffs				Contamination		Instruct	tions Incomplete/Unclear		Part Moved	[<u></u>	Wrong Stock Pulled
	\bigsqcup_{i}	Crushing				Countersink	L	1 ~	ned/off center	L	Positioned V	Vrong _		
	\vdash	Heat Trea				Cut Too Short		Mislabe		L	Power Loss/	Surge		Other
	-	Inspection	•	Tube	<u> </u>	Drawing		Misread						
	$\overline{}$	Marks/Ch			\perp	Drill Holes	<u> </u>	Off-set						
	\vdash	Turning S	-		<u> </u>	Finish	<u> </u>	1	Calibration					
	ı l'	Wave/Tw	ist in Tub	10	ı	Fit/Function	ı	Out of	Seguence					

Work Orde July-12-13 10:0		4470		*104	1470*							Page 2
Item ID: Revision ID:	D2237			Accept	*N900	<u>040</u>	100)*	Setup	Start Stop		S1*
Item Name: Start Date: Required Date: Reference:	7/12/13 : 7/12/13	Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*		Cust Item 1 Customer:	ID:				•	"IV.	S2*
Approvals:		an:		Tooling: SPC (Y/N):		ate:			Run	Start Stop	*NI *NI	R1* R2*
Sequence ID/ Work Center II 130 *120* Small Fab Small Fab	D	Operation Description Small Fab Memo 1-Form as po	er drawing	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accep Qty	t Rej Qty		Reject Number	Insp. Stamp /3(a)
.140 *140 * QC Quality Control		QC5- Inspect part compl Memo	eteness to step on W/O	0.00					Ø)	<u>13</u> -0	<u>10 -8¢</u>	<u>(lb</u>
150 *150* Packaging		Identify as per dwg & St Memo	ock Location: STW 7	0.00						1] <mark>8/8/</mark> [(n 61)

Packaging

DQA:			Date:			MODE ORDER NON	~	SNEOI	384481CE / 111	DDATE					`DART
QA Closed:			Date:			WORK ORDER NON-	-C(JINFOI	RIVIAINCE / UI		Wor	k Order up	date only		AEROSPACE
						DISPOSITION				AGAINST I	DEP#	ARTMENT/	PROCESS		
Work Orde	er: –	,	 			Downer! [Chief tuba	Crasstubal	\neg		Water Jet		Engineering
Part N	do					Rework Scrap			Skid-tube Machining	Crosstube Small Fab	\dashv	Prov	d. Eng. Coor.	\dashv	Engineering Quality
raiti	' '-				_	Use-as-is			noforming	Finishing	\dashv		e/Packaging	\dashv	Other
NCR N	No.					Suspected Unapproved			Large Fab	Composite	\dashv	1100,000	Supplier	_	
	_									·					
Root					Desci	ription of work order update	1	Initial	Act	ion		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption		Date	Verification	n	QC Inspector
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Material	Н														
Operator	Ц													l	
Offset/Setup	Н														
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Supplier	Н														
Training	Н													Ì	
Transport	Н														
Unapproved			<u>i</u>	L			FΔI	LILT CAT	regory					l	
Landi	ng G	ear				General		<u> </u>							
•		Bending				Bend		Folio/F	rogram	Г	Пс	outside Dim	ensions		Pressure/Forced
	П	Centre No	ot Concer	ntric		BOM/Route		Grain	· ·	Ţ	\Box_{c})ver/Under	tolerance	\vdash	Set-up
	П	Cracks				Broken/Damage/Defect		Hardwa	re	ļ	P	art Incorrec	:t	-	Temperature/Cure
		Crimp/Kit	nk/Ripple	/Wave		Burrs	Г	Inspect	ion Incomplete/Ur	nqualified	P	art Lost/Mi	ssing		Weld
		Cuffs				Contamination		Instruct	ions Incomplete/U	Jnclear	P	art Moved			Wrong Stock Pulled
		Crushing				Countersink		Misalie	ned/off center		P	ositioned W	/rong		
		Heat Trea	at			Cut Too Short		Mislabe			P	ower Loss/	Surge		Other
		nspectio	n Strip in	Tube		Drawing		Misread	d	•					
		Marks/Cl	natter			Drill Holes		Off-set			_				
		Turning S	equence			Finish		Out of (Calibration		_				
	Π,	Mave/Tu	ist in Tuk	10		Fit/Function		Out of	Soguence		_				

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Work Ord <i>July-12-13 10:0</i>		4470		*104	1470*						Page 3
Item ID: Revision ID: Item Name:	D2237 Striker Plate			Accept	*N900	040	100)* s	Setup Sta	I W	S1* S2*
Start Date: Required Date: Reference:	7/12/13 7/12/13	Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*		Cust Item I Customer:	D:					
Approvals:	Process Pla	an:	Date:	Tooling: SPC (Y/N):		ate:	30 to 1	F	Run Sta Sto	. a	R1* R2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
*160 *160* QC Quality Control		QC21- Final Inspection -	Work Order Release	0.00					MLJ	13-08 ML	5 13-08

DQA:			Date:			WORK ORDER NON	~	SNEOL	DRAANICE / LU					•	`DART
QA Closed:			Date:			WORK ORDER NON-	-CC	JINFUI	RIVIAINCE / U		Wa	ork Order up	odate only	\neg	AEROSPACE
14/ = ul. Oud			i .			DISPOSITION				AGAINST	DEF	PARTMENT	/PROCESS		
Work Orde	-					Rework	,		Skid-tube	Crosstube	_		Water Jet		Engineering
Part N	J۸					Scrap		,	Machining	Small Fab	\dashv	Pro	d. Eng. Coor.		Engineering Quality
ruiti	•0		:	 -		Use-as-is		L .	noforming	Finishing	\dashv		re/Packaging	\dashv	Other
NCR N	No.					Suspected Unapproved		*******	Large Fab	Composite	\dashv	rice, stor	Supplier	_	
				_											
Root					Desc	ription of work order update	1	nitial		ion		Sign &		Í	
Cause	_	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	ription	_	Date	Verification	1	QC Inspector
Design									±				:		
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Material	\dashv														
Operator	Н														
Offset/Setup	Н				<u> </u>										
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Supplier Training	\vdash								:						
Transport	\dashv					•									
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Landi	ng G	ear				General									
		Bending				Bend		Folio/P	rogram			Outside Dim	ensions	P	Pressure/Forced
	Ш	Centre N	ot Concer	ntric		BOM/Route		Grain				Over/Under	tolerance	s	Set-up
		Cracks				Broken/Damage/Defect		Hardwa	re			Part Incorred	ct	1	emperature/Cure
		Crimp/Ki	nk/Ripple	/Wave		Burrs	L	Inspect	on Incomplete/Ur	nqualified		Part Lost/Mi	ssing	\v	Veld
	Ш	Cuffs				Contamination	L	Instruct	ions Incomplete/l	Jnclear	Ш	Part Moved	L	\v	Wrong Stock Pulled
	\vdash	Crushing				Countersink	$oxed{oxed}$	1	ned/off center		$\boldsymbol{\vdash}$	Positioned V	· ·		
		Heat Trea				Cut Too Short	<u></u>	Mislabe	eled			Power Loss/	Surge		Other
	—-	•	n Strip in	Tube		Drawing	L	Misread	1						·
	-	Marks/Cl			L	Drill Holes		Off-set							
	_					Finish		4	Calibration						
	Turning Sequence Wave/Twist in Tube			16	- 1	Fit/Function	1	Dut of	Somience						

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July-12-13 10:03:50 AM

Work Order ID:

104470

Parent Item:

Comments:

D2237

Parent Item Name:

Striker Plate

IPP C02.05.11Clarify IPPNG IPP D 06.05.25 Waterjet EC

Start Date: 7/12/13

Required Date: 7/12/13

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S22GA 304/316 .032 Sheet		Purchased	No	,		100	sf	171.3800	0.01	0.2 105 26 O.25			<u>~13-07-3</u> 0
				Location		Loc Qty	<u>Lo</u>	c Code					
				MAT020		171.38							
				11827	1	10.76							
				12086	6	54.87							
				12188	9	105.75			121	<u> </u>			

DQĂ: 🎺 🔭	· .:		Date:											•	DA DT
						WORK ORDER NON-	-CC	ONFO	RMANCE / U	IPDATE					AEROSPACE
QA Closed:			Date:								W	ork Order up	odate only		
Work Orde	er:					DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		
	_					Rework			Skid-tube	Crosstube			Water Jet		Engineering
Part N	No.					Scrap		1	Machining	Small Fab		Pro	d. Eng. Coor.		Quality
	_		•			Use-as-is		Thern	noforming	Finishing		Rec/Sto	re/Packaging		Other
NCR I	No					Suspected Unapproved			Large Fab	Composite			Supplier		
Root					Desci	ription of work order update		Initial	Ac	tion	-	Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription		Date	Verification	1	QC Inspector
Design									,						
Doc/Data	Ш					·									
Equip/Tooling	Ц											i			
Handling/Pre	Ц														
Material	Н														
Operator	Н														
Offset/Setup	Н					,	1								
Process	Н														
Supplier	H								:						
Training	Н														
Transport Unapproved	H														
Опарргочец	Щ.				L		EAL	IUT CAT	L TEGORY				l		L
Landi	ne G	ear				General	FA	OLI CA	IEGONT			· · · · ·			
		Bending				Bend	\Box]Folio/P	rogram			Outside Dim	ensions [—	Pressure/Forced
	$\boldsymbol{\vdash}$	Centre No	t Concer	ntric		BOM/Route	一	Grain	rogram			Over/Under			Set-up
	$\boldsymbol{\vdash}$	Cracks				Broken/Damage/Defect		Hardwa	re			Part Incorred	- F		Temperature/Cure
	Π̈́	Crimp/Kin	k/Ripple	/Wave		Burrs		1	on Incomplete/U	Inqualified		Part Lost/Mi	-		Weld
	\blacksquare	Cuffs	• • • •			Contamination		1	ions Incomplete/	·		Part Moved	8	_	Wrong Stock Pulled
	П	Crushing				Countersink		1	ned/off center			Positioned V	L Vrong] og o.com : amea
		Heat Trea	t			Cut Too Short		Mislabe				Power Loss/			Other
	ı	nspection	Strip in	Tube		Drawing	Г	Misread		•		1	- L		
	ا ا	Viarks/Ch	atter			Drill Holes	Г	Off-set							
		Turning Se	equence			Finish		Out of (Calibration				····		***************************************
Turning Sequence Wave/Twist in Tube			Fit/Function		Out of 9	Sequence									

DART AEROSPACE LTD	Work Order:	10447e
Description: Striker Plate	Part Number:	D2237
Inspection Dwg: D2237 Rev: D1		Page 1 of 1

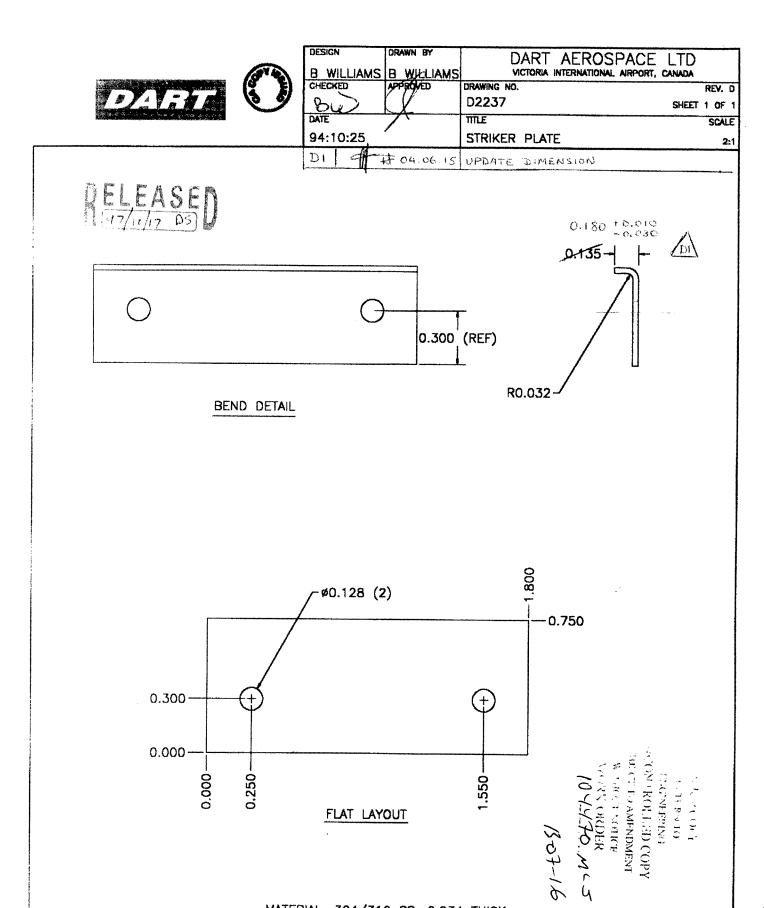
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.300	+/-0.010	0.303"	_		U	Jkmu:
0.250	+/-0.010	0.252	-		V	
1.550	+/-0.010	1.548	_		U	
1.800	+/-0.010	1.805	-		V	
0.750	+/-0.010	0.753")		V	
Ø0.128	+0.005/-0.001	0.131			V	
0.034	+/-0.010	0.030"	_		V	
l						

			, V, O,		
Measured by:	Jm	Audited by:	(0 9	Prototype Approval:	N/A
Date:	13.07.30	Date:	B.07.30	Date:	N/A

Rev	Date	Change	Revised	by	Approve/d
Α	07.05.31	New Issue	KJ/JLM	X	



MATERIAL: 304/316 SS, 0.034 THICK